

# NOTICE

Performance Surety Division

August 06, 2003

Notice No. 0125

## **Coordinate Measuring Machines**

**Background** The Department of Defense Investigator General (DOD IG) issued a Notification of potentially defective product on July 26, 2002, advising that beginning October 1998, L.S. Starrett Co. of Athol, MA, has been selling coordinate measuring machines (CMM) that have not been correctly calibrated.

The allegations concern possible deficiencies in the software, aluminum masts, and incorrectly installed probe heads in these machines.

The software deficiency allegation is specific to the models of L.S. Starrett CMM that contain Metrologic Co. software licensed to Starrett under the trademark "Apogee."

The possible design flaw in the aluminum masts concerns L.S. Starrett's Rapid Check II and Rapid Check III CMM fielded in approximately May 2000. The aluminum mast, which is heat sensitive, may expand or contract with temperature fluctuations, affecting the ability of the CMM to measure accurately. Later production models changed from aluminum masts to steel masts to alleviate the problem.

**Applicability** The requirements contained in this Notice shall apply to all organizations owning and/or using CMM.

**Requirements** Division Leaders and managers of organizations owning or using CMM shall ensure the following:

1. Receipt of the CMM Notice/Alert is acknowledged by e-mail ([sci@lanl.gov](mailto:sci@lanl.gov)) within one working week following receipt.
2. An investigation is conducted within their organization to determine if they have the L.S. Starrett CMM with “Apogee” software and / or aluminum masts and that the results of the investigation (positive or negative) are reported by e-mail to [sci@lanl.gov](mailto:sci@lanl.gov) within 2 weeks of the receipt acknowledgement of the Notice/Alert.
3. Owners or organizations reporting positive results (step 2), shall report within 30 working days by e-mail to [sci@lanl.gov](mailto:sci@lanl.gov) the following:
  - The impact within their processes resulting from the previous use and continued use of the CMM.
  - Any immediate actions taken, or planned to be taken, are identified, (hold, return, scrap, or \*continue using). \*Justification required.
  - Any compensatory (short and long-term) measures to be taken are identified.
  - The scheduled dates for completing the required actions.
4. Completion of each of the required actions is reported to PS-1 by e-mail to [sci@lanl.gov](mailto:sci@lanl.gov), including the dates the required actions were completed.

**Questions?** Contact PS-1, Institutional Quality Management, 665-6377 or 665-5437.



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*The OIC for this notice is **PS-1, Institutional Quality Management**, and the responsible division director is (PS-DO). This notice shall remain in effect for (180 days).*